

Shy Mayb


EURO CORP

Work Order ID 67702



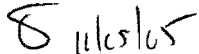




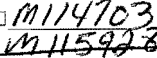

Tuesday, March 29, 2011 1:05:26 PM

Item ID: D350-591-311 Accept  Setup Start 
Revision ID:
Item Name: Heli-Access-Step, Long LH Stop 
Start Date: 3/29/2011 Start Qty: 10.00  Cust Item ID:
Required Date: 5/6/2011 Req'd Qty: 10.00  Customer:
Reference:
Run Start 
Stop 

Approvals: Process Plan:  Date: 11-03-29 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3272	Rev B								

100  0.00
DC  0.00
Document Control Memo Photocopy bluefile and type labels as per PPP D350-591-311 CHG001 

110  0.00
Large Fab  0.00
Large Fab Memo 1-Bevel end for welding FWD ONLY
2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272
A/R ☐ Aluminum Rod 
3-Grind End Plate flush 

Work Order ID 67702

Page 2

Tuesday, March 29, 2011 1:05:26 PM

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 3/29/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10 0 8-11/04/27

130

QC5- Inspect part completeness to step on W/O

0.00



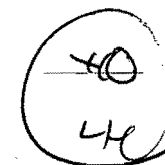
QC

Memo

0.00

Quality Control

8 11/04/27



140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10 0 11-04-28

10 0 11-04-28

Work Order ID 67702

Tuesday, March 29, 2011 1:05:26 PM



Page 3

Item ID: D350-591-311

Revision ID:

Item Name: Heli-Access-Step, Long LH

Start Date: 3/29/2011 Start Qty: 10.00

Required Date: 5/6/2011 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Run Start



Stop



Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11-04-29

10

0

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

11-04-29

10

0

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

SAO 11-04-29

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R ☐ Aluminum Rod ☒ M114703

6-Grind End Plate flush

SAO 11-04-29

7-Install last rivet as per Dwg.

Work Order ID 67702

Tuesday, March 29, 2011 1:05:26 PM



Page 4

Item ID: D350-591-311

Revision ID:

Item Name: Heli-Access-Step, Long LH

Start Date: 3/29/2011 Start Qty: 10.00

Required Date: 5/6/2011 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Run Start



Stop



Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8 11/05/03

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11/05/03

(X10
MM)

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

X10614 8 11/05/04

Work Order ID 67702

Tuesday, March 29, 2011 1:05:26 PM



Page 5

Item ID: D350-591-311

Revision ID:

Item Name: Heli-Access-Step, Long LH

Start Date: 3/29/2011 Start Qty: 10.00

Required Date: 5/6/2011 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M 116 964

Memo

0.00

10

Bl 11-5-4

Powder Coating

START TIME: 11:50
OVEN TEMPERATURE: 320°
FINISH TIME: 12:20

230

Wing Walk as per dwg QSI005 4.4 Batch M 117140

0.00



HandFinish

Memo

Hand Finishing

X1064 M 1105/04

240

QC3- Inspect Part Finish

0.00



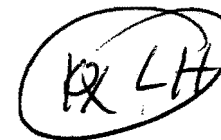
QC

Memo

0.00

Quality Control

=> m-l 11/05/04



Work Order ID 67702

Tuesday, March 29, 2011 1:05:26 PM



Page 6

Item ID: D350-591-311

Revision ID:

Item Name: Heli-Access-Step, Long LH

Start Date: 3/29/2011 Start Qty: 10.00

Required Date: 5/6/2011 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Run Start



Stop



Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/5/4 SP 100

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8 units

410
64

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311
Location: _____

Rao B

11/5/5 SP 100

Work Order ID 67702

Tuesday, March 29, 2011 1:05:26 PM



Page 7

Item ID: D350-591-311
Revision ID:
Item Name: Heli-Access-Step, Long LH
Start Date: 3/29/2011 Start Qty: 10.00
Required Date: 5/6/2011 Req'd Qty: 10.00
Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____
QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

4/5/9

4/11-05-4
(10)

Picklist Print

Tuesday, March 29, 2011 1:05:32 PM

Page 1

Work Order ID: 67702

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH


Start Date: 3/29/2011

Required Date: 5/6/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
 IPP Rev:B 07-06-09 Added D3272-1 JLM
 IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
 IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1 		Manufactured	No			110	Each	0.0000	1	10			
Step													
D3067-1 		Manufactured	No			110	Each	69.0000	1	10			
End Plate													
<div> <div>Location</div> <div>WA016 <u>B67582</u></div> <div>65969</div> </div> <div> <div>Loc Qty</div> <div>69</div> <div>69</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3219-1 		Manufactured	No			110	Each	56.0000	2	20			
Plate													
<div> <div>Location</div> <div>WA017 <u>B67580</u></div> <div>66133</div> </div> <div> <div>Loc Qty</div> <div>56</div> <div>56</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3066-1 		Manufactured	No			180	Each	53.0000	2	20			
Spacer													
<div> <div>Location</div> <div>WA015</div> <div>66131</div> </div> <div> <div>Loc Qty</div> <div>53</div> <div>53</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

B67581

→ 20

11.04.25 B67707 (10)

11.04.26

5
105

11.04.26

20

SAD 12.04.29

Picklist Print

Tuesday, March 29, 2011 1:05:32 PM

Page 2

Work Order ID: 67702

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/29/2011

Required Date: 5/6/2011

Start Qty: 10.00

Required Qty: 10.00

MS20600-AD4W4

Purchased

No

180

Each

1,600.000

16

160



Rivets



SAD 11-04-29

Location

Loc Qty

Loc Code

ST321

1500

116188

1500

160

WA018

100

116712

100

D3065-041

Manufactured

No

180

Each

47.0000

1

10



Step Leg Assembly Hi



SAD 17-04-29

Location

Loc Qty

Loc Code

WA014

47

367503

27

66149

20

66808

20

M67503

5

5

D3067-1

Manufactured

No

180

Each

69.0000

1

10



End Plate



11-04-29

Location

Loc Qty

Loc Code

WA016

69

367582

69

65969

69

20

AN3-35A

Purchased

No

250

Each

75.0000

2

20



Bolt



M117313 11/17/10

Location

Loc Qty

Loc Code

ST353

75

116191

75

Tuesday, March 29, 2011 1:05:33 PM

Shop Packet Print

Page 2

Picklist Print

Tuesday, March 29, 2011 1:05:33 PM

Work Order ID: 67702

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/29/2011

Required Date: 5/6/2011

Start Qty: 10.00

Required Qty: 10.00

D3235-1 Manufactured No

250 Each

67.0000 2 20



Mounting Lug



B67831 SP

Location Loc Qty Loc Code

ST471 67

65073 7

66941 60

D3278-041 Manufactured No

250 Each

55.0000 1 10



Support Assembly



B67584 SP

Location Loc Qty Loc Code

ST471 55

66155 15

66946 40

AN960JD416 NAS1149D0463J Purchased No

250 Each

0.0000 16 160 16



Washer



M117065 M117291 SP

AN960JD516 NAS1149D0563J Purchased No

250 Each

0.0000 4 40



Washer



M117291 SP

AN5-36A Purchased No

250 Each

97.0000 2 20



Bolt



M117366 11/5/4 SP

Location Loc Qty Loc Code

ST341 97

116704 97

20 M117366

Picklist Print

Tuesday, March 29, 2011 1:05:33 PM

Page 4

Work Order ID: 67702

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/29/2011

Required Date: 5/6/2011

Start Qty: 10.00

Required Qty: 10.00

D2618 Manufactured No

250 Each

94.0000 2

20



Bushing



B68249

Location

Loc Qty

Loc Code

ST019

94

66942

94

250 Each

27.0000

4

40

362

D2230-3 Manufactured No



Lug



B67927

B65090

sf

Location

Loc Qty

Loc Code

Return 2010

4

62927

2

63544

2

ST470

27

66936

27

250 f

25.5200

1.2

12

D2856-400 Manufactured No



Abraison Strip



B68076

Location

Loc Qty

Loc Code

ST409

25.52

63735

25.52

250 Each

2,189.000

2

20

*** cut (2) at 7.20" (D2856-400-720) ***

MS21042L3 Purchased No



Nut



1154

100

Location

Loc Qty

Loc Code

ST300

2189

116391

589

116540

800

116549

800

20

Tuesday, March 29, 2011 1:05:33 PM

Shop Packet Print

Page 4

Picklist Print

Tuesday, March 29, 2011 1:05:33 PM

Work Order ID: 67702

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 3/29/2011

Required Date: 5/6/2011

Start Qty: 10.00

Required Qty: 10.00

AN4-13A Purchased No

250 Each

336.0000 8 80



Bolt



M11731 3

Location

Loc Qty

Loc Code

ST357

336

116786

36

117094

300

MS21042L5 Purchased No

250 Each

941.0000 2 20



Nut



sp

Location

Loc Qty

Loc Code

ST300

941

115594

181

116105

500

116548

260

MS21042L4 Purchased No

250 Each

3,324.000 8 80



Nut



sp

Location

Loc Qty

Loc Code

ST300

3324

116188

1324

116823

2000

AN960JD10 NAS1149D0363J Purchased No

250 Each

0.0000 4 40



Washer



11614 sp M116583 sp 701

DART

DESIGN <i>QP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

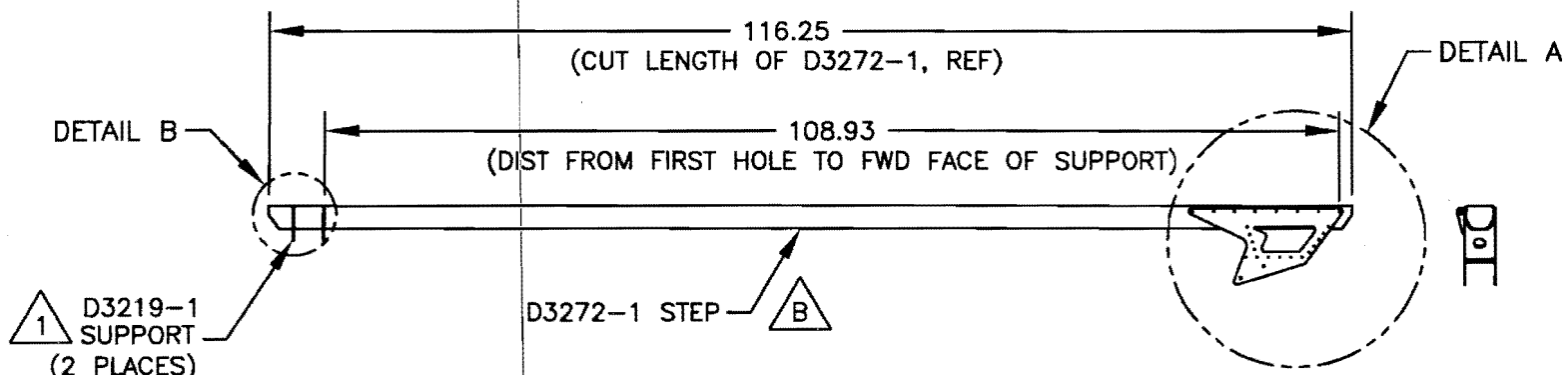
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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *67702*

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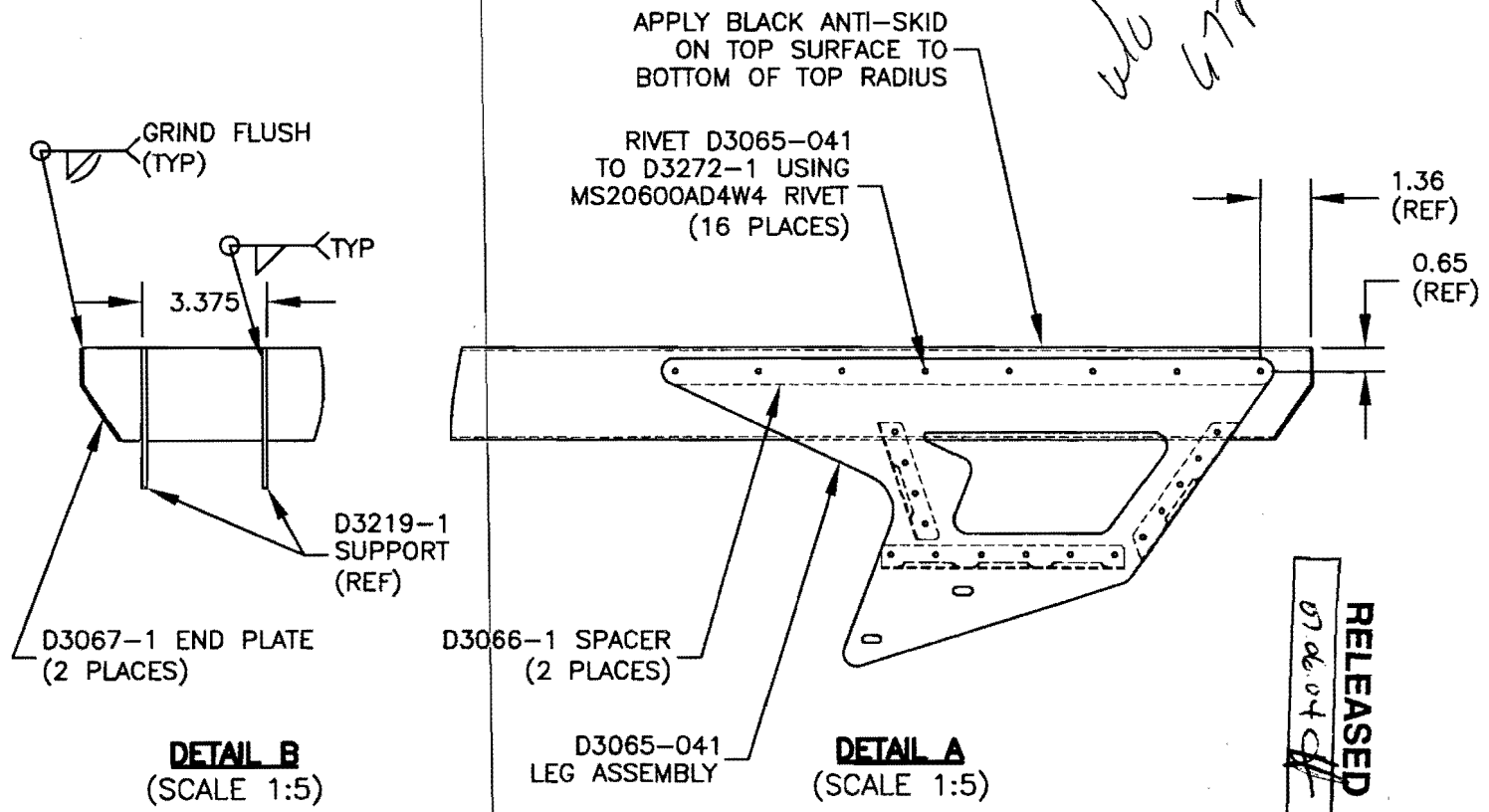
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DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. B
07.05.18	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE
		1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DETAIL B
(SCALE 1:5)

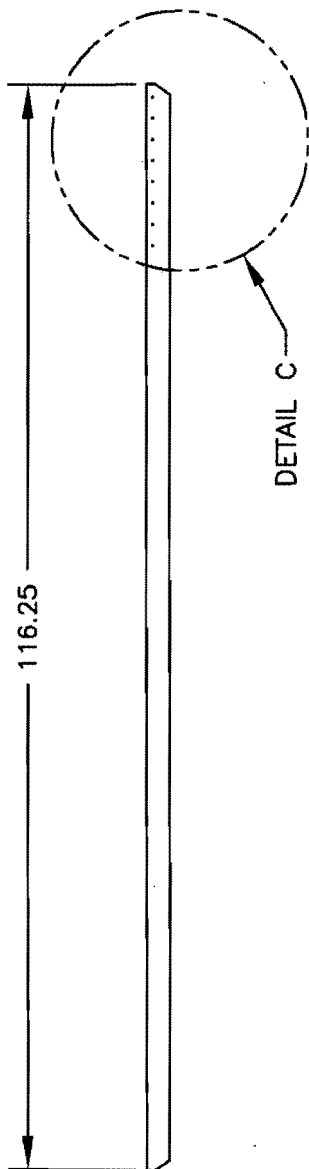
DETAIL A
(SCALE 1:5)

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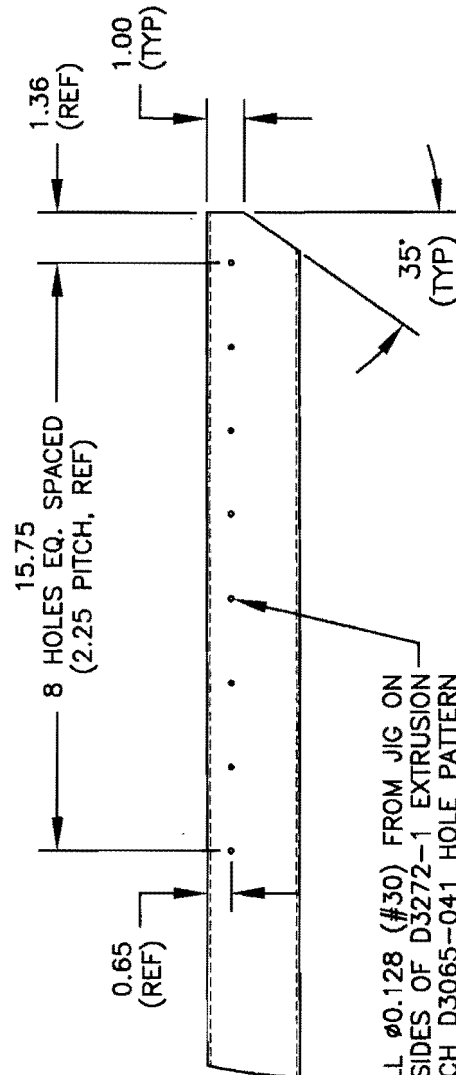
DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



DETAIL C

u/b 67709

△ B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

RELEASED

07.06.04 *[Signature]*

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.